

Date: Thursday, 6/21/2007 2:35:03 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 33092	
Estimate Number : 10892	
P.O. Number : <u>N/A</u>	Part Number : D32861
This Issue : 6/21/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3286 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32514	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 7/10/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>34</u> Um: Each
Comment : Est A 04.07.14 New issue KJ/JLM Est Rev:B Now on Waterjet 06-06-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0786 sf(s)/Unit Total : 2.3594 sf(s)

304/316 .125 Sheet

Batch: M/02 817

SAN 07/06/24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3286

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

> m/07/07/24 (x34)

SAN 07/06/24

P10

(34)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/06/23

(31)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/25

(counted)

(x34)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

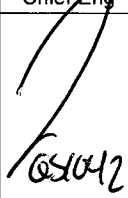

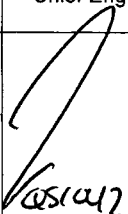

Form as per Dwg D3286

[Signature] 07-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 07/07/30

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/25	2.0	One part Scrap, Part moved when Water jet was cutting	 05/04/2	Scrap. destroy replace	SAD 07/06/25	 07/06/25	 05/04/2	 07/06/25

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:35:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33092

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/30

(34)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

En 07/07/30 (34)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(31)

Comment: FINAL INSPECTION/W/O RELEASE

En 07/07/30

Job Completion



En 07/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

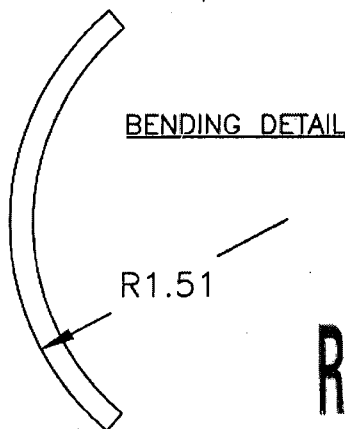
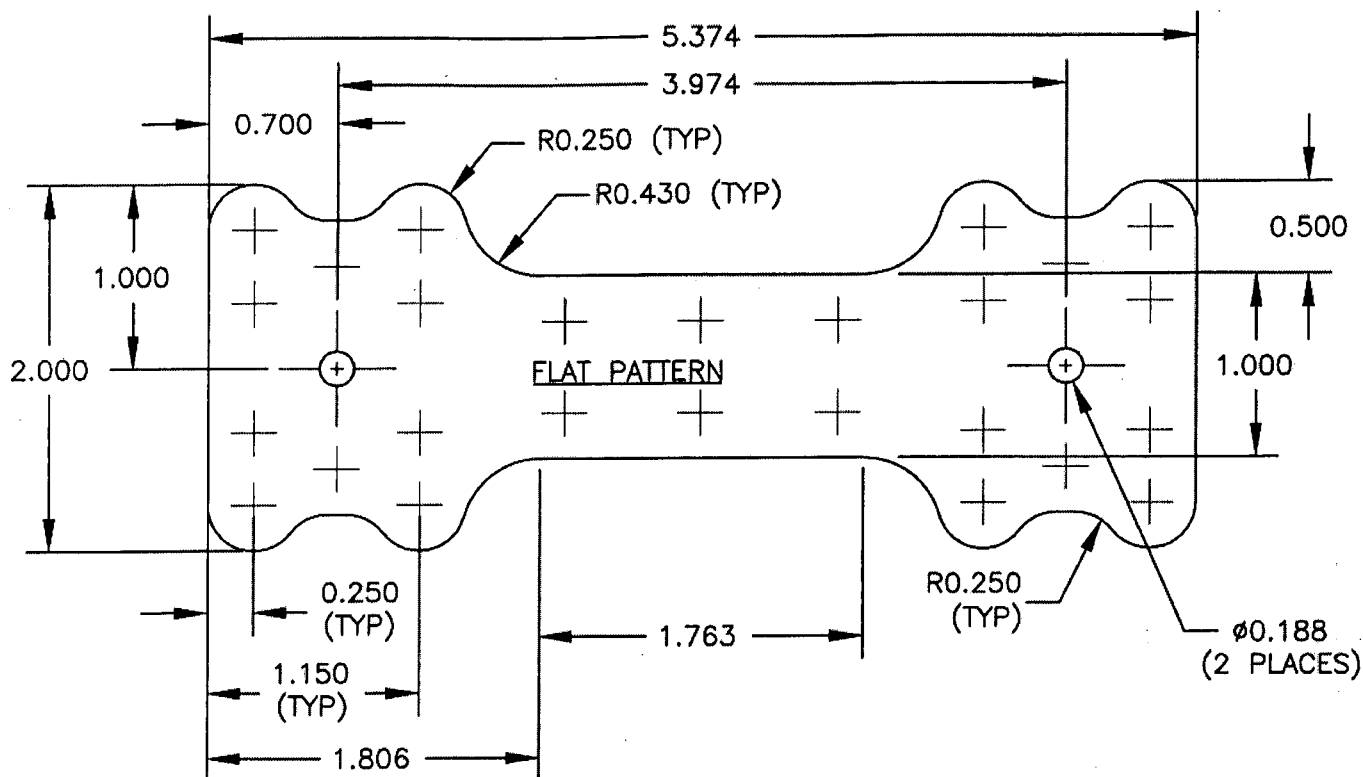
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



RELEASED
04.06.22

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

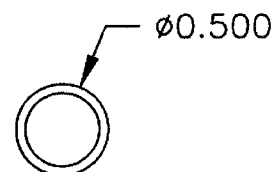
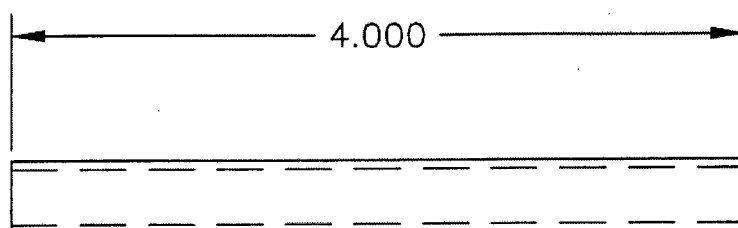
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *[Signature]*

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